

Date: Monday, 28/04/2008 8:14:57 AM
 User: Julie Lecocq

Process Sheet

| | | | | | | | |
|---|--|-----------------|---------------------|-------------------------|-----------------------|-----------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : HINGE HALF | | | |
| Job Number | : 38826 | | | | | | |
| Estimate Number | : 13157 | | | | | | |
| P.O. Number | : | | | Part Number | : D37491 | | |
| This Issue | : 28/04/2008 | S.O. No. | : | | Drawing Number | : D3749 REV A | |
| Prsht Rev. | : NC | | | | Project Number | : N/A | |
| First Issue | : / / | | Type | : SMALL /MED FAB | | | |
| Previous Run | : 37202 | | | Drawing Revision | : A | | |
| Written By | : | | | Material | : | | |
| Checked & Approved By | : <u>JL</u> 08.4.28 | | | Due Date | : 10/05/2008 | | |
| Comment | : Est Rev:A 08-02-05 new issue DD verified by:EC | | | Qty: | 20 | Um: Each | |
| Comment : Est Rev B 08-02-27 rev.A as per ecn 1139 DD verified by: | | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---|
| 1.0 | M304S11GA | 304/316 .125 Sheet |
| | | |
| | | Comment: Qty.: 0.0196 sf(s)/Unit Total : 0.3927 sf(s) 304/316 .125 Sheet (M304S0125) Batch: <u>104934</u> FB 8-4-29 |
| 2.0 | WATER JET | FLOW WATER JET |
| | | |
| | | Comment: FLOW WATER JET 1-Cut as per Dwg D3749 Dwg Rev: <u>A</u> FB 8-4-29 Prog Rev: <u>A</u> |
| | | 2-Deburr if necessary |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | <u>FB 8-4-29</u> |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE |
| 4.0 | QC8 | SECOND CHECK |
| | | <u>S 08/04/30 +32</u> |
| | | Comment: SECOND CHECK |
| 5.0 | BRAKE NC | NC BRAKE |
| | | <u>S 08/05/31 +32</u> |
| | | Comment: NC BRAKE Form as per Dwg D3749 using CNC Brake |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Monday, 28/04/2008 8:14:57 AM
User: Julie Lecocq

Process Sheet

| Customer: CU-DAR001 Dart Helicopters Services | | Drawing Name: HINGE HALF |
|---|-----------------------|---|
| Job Number: 38826 | | Part Number: D37491 |
| Job Number: | |  |
| Seq. #: | Machine Or Operation: | Description : |
| 6.0 | QC5 | INSPECT WORK TO CURRENT STEP  |
| Comment: INSPECT WORK TO CURRENT STEP | |  S080501 X32 counter |
| 7.0 | PACKAGING 1 | PACKAGING RESOURCE #1  |
| Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WS7 | |  C08.05.01 X32 |
| 8.0 | QC21 | FINAL INSPECTION/W/O RELEASE  |
| Comment: FINAL INSPECTION/W/O RELEASE | | 08/05/05 JH |
| Job Completion | |  MF 08-05-02 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

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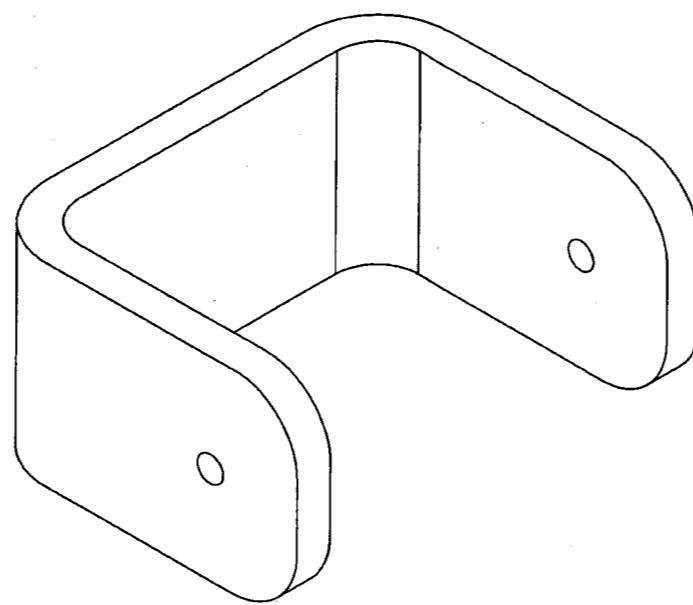
C

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A

A



D3749-1 HINGE HALF

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38824

LE 08.02.25

NOTES:

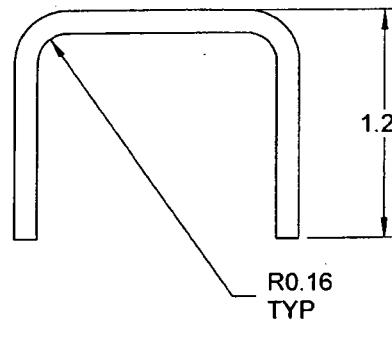
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

| A | NEW ISSUE | | AJS | 08.02.01 |
|------------|-------------|--|-------------|--------------|
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | ASS | | | |
| CHECKED | LE | | DRAWING NO. | |
| MFG. APPR. | MD | | D3749 | REV. A |
| APPROVED | MD | | TITLE | SHEET 1 OF 2 |
| DE APPR. | # | | HINGE HALF | SCALE NTS |
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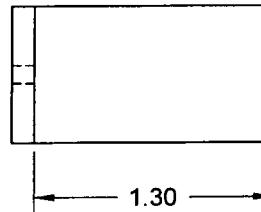
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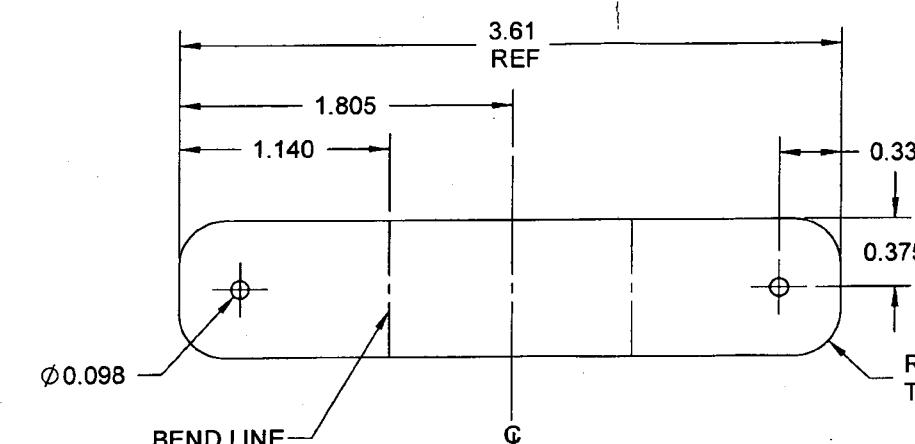
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D3749-1 HINGE HALF



D3749-1F FLAT PATTERN

LE 08.02.25

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| | | | |
|--|----------|--|-------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | LE | DRAWING NO. | |
| MFG. APPR. | AS | REV. A | |
| APPROVED | AS | D3749 | |
| DE APPR. | AS | SHEET 2 OF 2 | |
| DATE | 08.02.01 | TITLE | SCALE |
| | | HINGE HALF | |
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DART AEROSPACE LTD

Work Order: 38826

Description: HUGE HAIF

Part Number: D 37-49 - 1

Inspection Dwg: D3749-1 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by

10

Audited by

Prototype Approval:

二三九

8-11-2

Notes

80

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |